

Work Order ID 52922

October 19, 2009 10:56:31 AM

Page 1

Item ID: D3956-1

Accept

Revision ID: A

Item Name: Hinge, Airframe Upper

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 8.00

Required Date: 11/02/09 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3956

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3956

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

= 7 m-l 09/11/02

IB 9-10-09

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

16x

IB 9-10-09

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Start Date: 10/19/09 Start Qty: 8.00

Required Date: 11/02/09 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

⇒ 509/10/09

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ 09-11-3

HandFinish

Memo

0.00

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M4112148

⇒ 09/11/09

Powdercoat

Memo

0.00

Powder Coating

Start Time: 8:30 AM
Oven Temperature: 320°-
Finish Time: 9:00 AM

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Page 3

Item ID: D3956-1

Accept

Revision ID: A

Item Name: Hinge, Airframe Upper

Start Date: 10/19/09 Start Qty: 8.00

Required Date: 11/02/09 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC3- Inspect Part Finish

0.00

BR 09-11-4

16



QC

Memo

0.00

Quality Control

160 Identify as per dwg & Stock Location: 135

0.00



Packaging

Memo

0.00

Packaging

170 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

PC 09/11/04 16

09/11/04

PO 09-11-4

Picklist Print

October 19, 2009 10:56:36 AM

Page 1

Work Order ID: 52922

Parent Item: D3956-1A-PRELIM

Parent Item Name: Hinge, Airframe Upper


Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.250		Purchased	No			100	sf	29.5500	2.8632			
												
6061T6 SHEET .250												

139-10-21

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

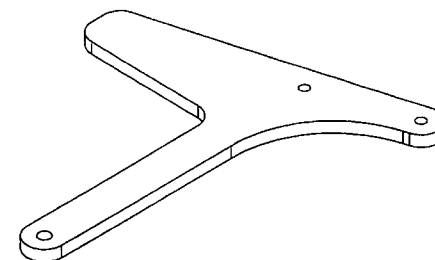
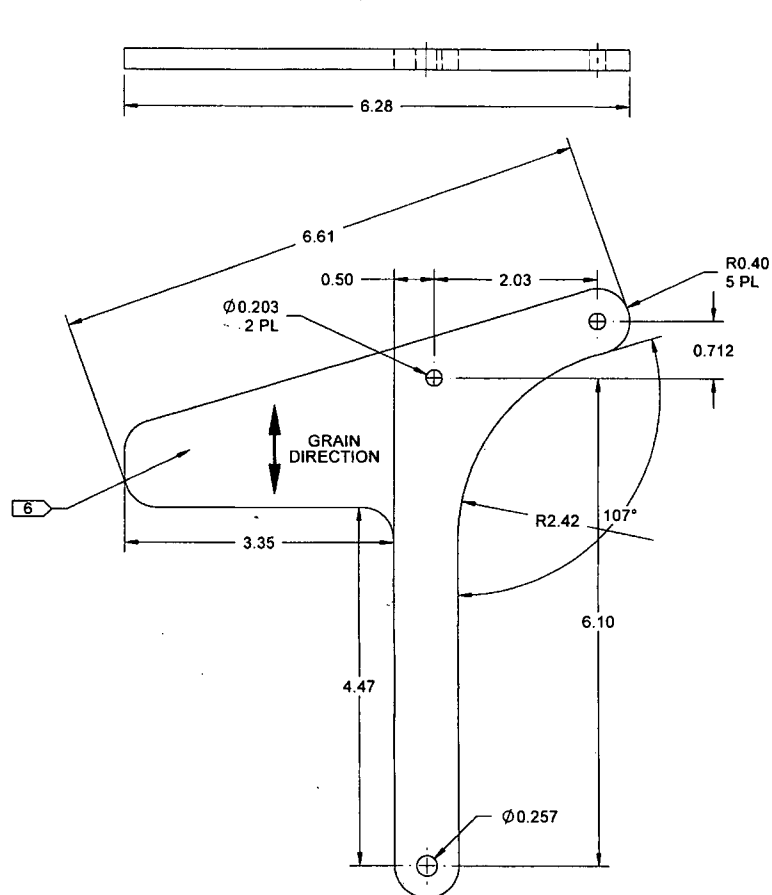
MAT

112663

29.55

29.55

112663



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WORK ONLY
NO. 52922

PL 09-10-19

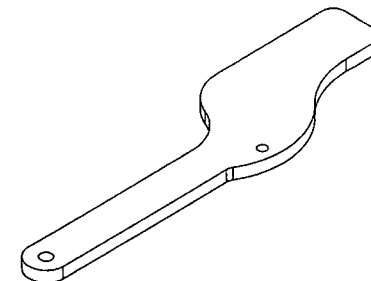
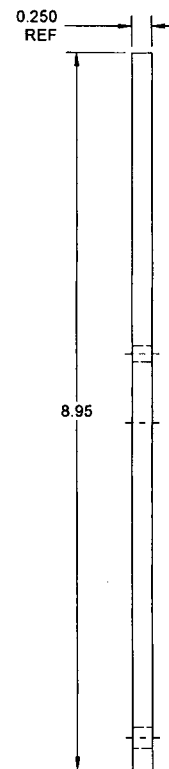
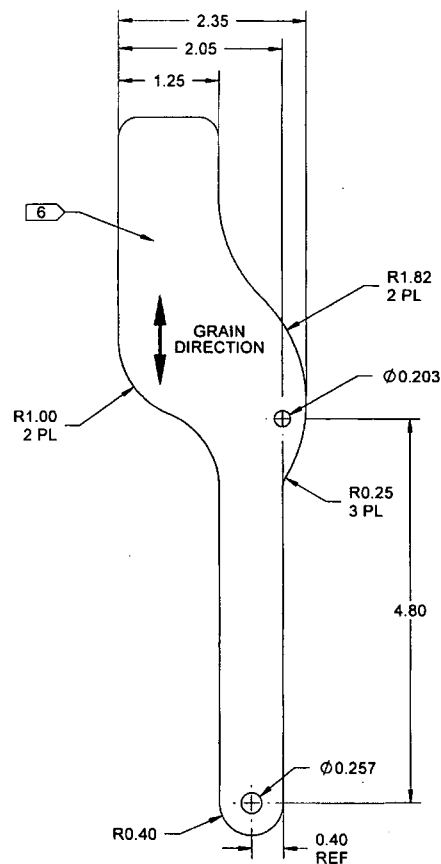
RELEASED
2009-10-08
JMT

D3956-1 HINGE, AIRFRAME UPPER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3956-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

A		NEW ISSUE		09.09.14	
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD			
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2009-10-08
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D3956-3 HINGE, AIRFRAME LOWER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3956-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

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